

NCL-19-7582



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5638-1

Job Sheet 197943



Part No: D5638-1

Job Qty: 4 pcs

Part Name: Saddle, Outboard, LH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/2/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D5638 REV.A IPP REV.A NEW ISSUE 19/02/06 JFS VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Machining - Issue SN	4 pcs	8/2/19		0.00	0.00	HAAS - 1		SBL/19/08/19
							HAAS - 2		
							HAAS - 3		
							HAAS - 4		
110	HAAS 4 Axis - B4B	4 pcs	8/2/19		3.00	4.44	HAAS - 1 - B4B		SBL/19/08/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	4 pcs	8/2/19		0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		



Container No: S206793



Part: D5638-1

Job No: 197943

Serial No/Batch: S206793

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/19/19

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130 QC 8	4 pcs	8/2/19	0.00 0.00	QC 2 - 57	SBL 19/08/23
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
140 Handfinish - 1-1 Chemical- B4B	4 pcs	8/2/19	0.00 0.50	QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
150 QC 7	4	8/2/19	0.00 0.00	Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	

SBL 19/08/23

AUG 26 2019

	pcs				QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	AUG 27 2019 DAS 68
					QC 7 - 50	9-89
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
152 Spray Paint - 2 - B4B	4 pcs	8/2/19	0.00 2.00		Spray Paint - 1 - B4B	RD 19-8-27
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	
					Spray Paint - 4 - B4B	
154 QC 14	4 pcs	8/2/19	0.00 0.00		QC 14 - 15	AUG 28 2019 DAS 40 9-89
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	
					QC 14 - 51	
					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	
					QC 14 - 24	
					QC 14 - 61	
					QC 14 - 81	
160 Packaging 3-1 - Stock - B4B	4 pcs	8/2/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	

				Packaging 3 - 12 - B4B					
				Packaging 3 - 13 - B4B					
				Packaging 3 - 14 - B4B					
				Packaging 3 - 15 - B4B					
				Packaging 3 - 16 - B4B					
				Packaging 3 - 17 - B4B					
				Packaging 3 - 18 - B4B					
				Packaging 3 - 19 - B4B					
				Packaging 3 - 20 - B4B					
				Packaging 3 - 21 - B4B					
				Packaging 3 - 22 - B4B					
				Packaging 3 - 23 - B4B	PC ST352A				
				Packaging 3 - 24 - B4B					
				Packaging 3 - 25 - B4B					
				Packaging 3 - 26 - B4B					
				Packaging 3 - 27 - B4B					
				Packaging 3 - 28 - B4B					
				Packaging 3 - 29 - B4B					
				Packaging 3 - 30 - B4B					
				Packaging 3 - 31 - B4B					
				Packaging 3 - 32 - B4B					
				Packaging 3 - 33 - B4B					
				Packaging 3 - 34 - B4B					
				Packaging 3 - 35 - B4B					
				Packaging 3 - 36 - B4B	AUG 3 11 2019				
				170 QC 21 - SA	4 pcs	8/2/19	0.00 0.00	QC 21 - SA - 21	
								QC 21 - SA - 70	ST352A
								QC 21 - SA - 53	
				Part Op 110 - 1-Machine per folio FC510 DWG REV: <u>A</u> FOLIO REV: _____ 2- Deburr and break all sharp edges Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB) 130 - (QC8- Inspect parts - second check) 140 - (Chemical Conversion Coat per QSI005 4.1) 150 - (QC7-Inspect Chemical Conversion Coat) 152 - PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER) BATCH: <u>5200299</u> PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT) BATCH: <u>5155871</u> 154 - (QC14- Inspect Spray Paint) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					
				Job BOM					
				Part / Item	Component Name	Quantity	Operation	Container	
				D6101-003	Saddle Billet, 7075	4 pcs (1 ea)	100-Machining - Issue SN		
				Job Allocations					
				Operation	Component Part	Required	Inventory	Allocated	
				100-Machining - Issue SN	D6101-003	46	43	0	
				Part Specifications					
Specifications could not be found.									

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DART AEROSPACE LTD		Work Order:	197943
Description: SADDLE COTBD		Part Number:	DS638-1
Inspection Dwg: P5638 Rev: A	DSK:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions					
				1	2	3	4	5	6
A	0.635	0.645		0.640	0.640	0.639	0.639	0.639	0.640
B	1.395	1.405		1.400	1.400	1.400	1.400	1.400	1.400
C	1.395	1.405		1.400	1.400	1.400	1.400	1.400	1.400
D	1.870	1.880		1.875	1.875	1.875	1.875	1.875	1.875
E	1.870	1.870		1.875	1.875	1.875	1.875	1.875	1.875
F	2.256	2.262		2.258	2.257	2.257	2.257	2.257	2.257
G	2.328	2.338		2.334	2.333	2.333	2.333	2.333	2.333
H	1.943	1.953		1.946	1.946	1.945	1.945	1.946	1.946
I	.110	.130		.121	.120	.120	.120	.120	.120
J	R.350	R.410		.375	.375	.375	.375	.375	.375
K	0.02 x .45	0.08 x .45		.050	.065	.050	.050	.050	.050
L	.241	.261		.255	.245	.255	.254	.253	.253
M	R.156.5	R.158.5		1.575	1.575	1.575	1.575	1.575	1.575
N	.490	.510		.500	.500	.500	.500	.500	.500
O	0.675	0.695		.690	.687	.690	.690	.690	.690
P	R.0.470	R.0.530		.500	.500	.500	.500	.500	.500
Q	.110	.130		.117	.112	.120	.120	.120	.120
R	R.1.125	R.1.145		1.135	1.135	1.135	1.135	1.135	1.135
S	1.346	1.366		1.353	1.352	1.353	1.353	1.353	1.352
T	.213	.233		.220	.225	.220	.220	.221	.220
U	.113	.133		.120	.125	.120	.121	.121	.120
V	R.160	R.220		.188	.185	.188	.188	.188	.188
W	5.990	6.010		6.000	6.000	6.000	6.000	6.000	6.000
X	1.070	1.130		1.104	1.100	1.100	1.110	1.110	1.110
Y	6.990	7.010		7.000	7.000	7.000	7.000	7.000	7.000
Z	.490	.510		.500	.500	.500	.500	.500	.500
AA	.350	.410		.378	.377	.378	.378	.378	.378
AB	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
AC	2.495	2.505		2.500	2.500	2.500	2.500	2.500	2.500
AD	1.245	1.255		1.250	1.250	1.250	1.250	1.250	1.250
AE	.400	.510		.497	.495	.497	.497	.497	.497
AF	.312	.318		.313	.313	.313	.313	.312	.312
AG	.510	.515		.512	.512	.512	.512	.512	.512
AH	.235	.240		.238	.232	.238	.237	.237	.237

Accept/Reject

Measured by: SBL	Date: 19/08/22
Audited by: [Signature]	Date: 19/08/26
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.11.08	Reformat	KJ/JLM	
C	12.07.31	Prototype revised to preliminary	KJ	

Entered: TR Date: Oct 28/19



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 19-7582

Route update only ☐

Job: <u>197 943</u> Part No. <u>D5638-1</u>	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐		
Date: <u>11/8/22</u>	Sequence #: <u>110</u>	QTY Affected: <u>1 6</u>	MRB (QSI042) <u>WSP</u> <u>12</u> <u>9/19/8/22</u>	
Description Work Order Deviation Thickness at saddle-to-skid tube groove is 0.232 - 0.227. Dwg = 0.235 +0.005/-0.000		Disposition Acceptable. Margins of safety of SR-D505-1057-1 are still positive. Min M.S. = 27.		
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☒ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
		Completed By <u>marc</u> <u>9/19/8/22</u>		
		Lead hand / Supervisor <u>B</u> <u>19-08-26</u>		
		QC / QA Coordinator <u>DAS</u> <u>68</u> <u>9-89</u> AUG 26 2019		
		Other/Details:		